

Work Order ID 53462

November 6, 2009 8:22:14 AM



Page 1

Item ID: D3535-15

Accept



Setup Start



Revision ID: B

Stop



Item Name: Wearshoe

Start Date: 05/11/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

09-11-5

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3535

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535 ☐ Dwg Rev: *B* ☐ Prog Rev: *B* ☐ 2-
Deburr if necessary

LB 9-11-11

(13)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

LB 9-11-11

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control



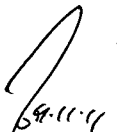
12

05-11-12

P10
11/11/09
11/11/09

W/O: 53462

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09-11-12	120	Took 1 part for templates for inspection.		09-11-12	1		

Part No: D3535-15 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53462

November 6, 2009 8:22:14 AM



Page 2

Item ID: D3535-15

Revision ID: B

Item Name: Wearshoe

Start Date: 05/11/2009 Start Qty: 6.00

Required Date: 13/11/2009 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start _____
Stop _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	NC BRAKE	0.00				12	0		
Brake NC	Memo	0.00							
Brake NC	1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326 2-Form joggle as per Dwg D3535 using Jig DT8158 3-Identify as D3535-15								
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
150 	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 9:00 AM FINISH TIME: 9:30 AM OVEN TEMPERATURE: 320 F								

8/20/17

2/8/17

9/11/19

Work Order ID 53462

November 6, 2009 8:22:14 AM



Page 3

Item ID: D3535-15

Accept



Setup Start



Revision ID: B

Stop



Item Name: Wearshoe

Start Date: 05/11/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

Ref 09-11-19

(12)

170



Packaging

Packaging

Identify as per dwg & Stock Location *FP.18*

Memo

0.00

0.00

Ref 09-11-19

(12)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

Ref 09-11-19
(12)

Picklist Print

November 6, 2009 8:22:19 AM

Page 1

Work Order ID: 53462

Parent Item: D3535-15RevB

Parent Item Name: Wearshoe


Comments:

Start Date: 05/11/2009

Required Date: 13/11/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	381.2528	6.4453	14.		
												
304/316 .040 Sheet												

189-11-11

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	381.2528158	
110076	1.37053684	
111571	0.94	
112567	39.7844789	
112885	83.1578	
113062	192	
113077	64	

13

113077

DART AEROSPACE LTD		Work Order: 53462
Description: Wearshoe		Part Number: D3535-15
Inspection Dwg: D3535	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.888	*			
2.000	+/-0.010	2.000	*			
5.650	+/-0.010	5.650	*			
9.150	+/-0.010	9.150	*			
14.400	+/-0.010	14.400	*			
19.650	+/-0.010	19.650	*			
24.900	+/-0.010	24.900	*			
30.150	+/-0.010	30.150	*			
33.650	+/-0.010	33.650	*			
35.650	+/-0.010	35.650	*			
39.150	+/-0.010	39.150	*			
Ø0.188	+0.005/-0.001	.188	*			
24.00	+/-0.030	24.00	*			
16.00	+/-0.030	16.00	*			
8.00	+/-0.030	8.00	*			
5.00	+/-0.030	5.00	*			
0.300	+/-0.010	.303	*			
0.300	+/-0.010	.300	*			
0.038	+/-0.010	.035	*			

Measured by: AB	Audited by: [Signature]	Prototype Approval:	N/A
Date: 9-11-11	Date: 6-11-12	Date:	N/A

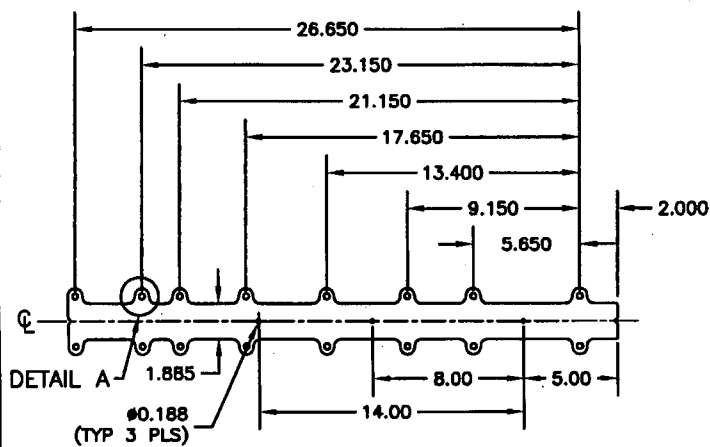
Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM [Signature]	[Signature]

DART

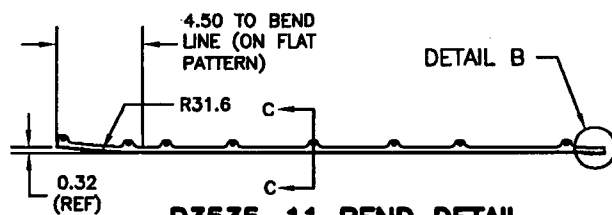
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07.04.17

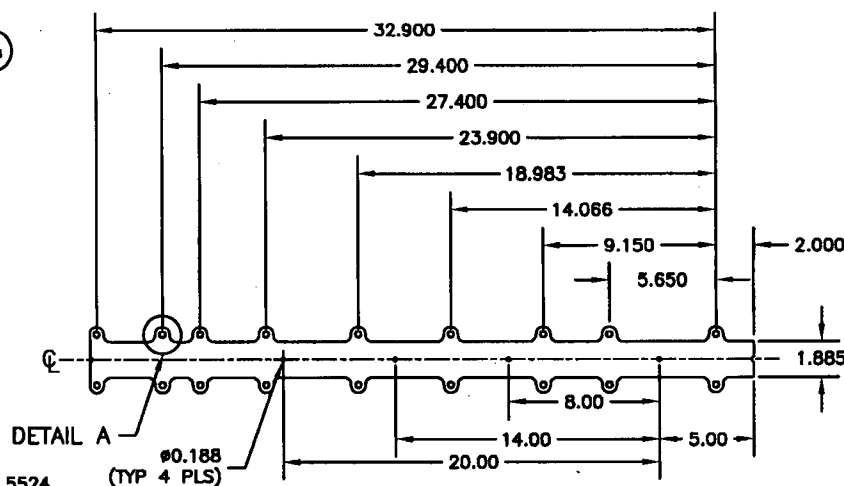
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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53462
BY 09-11-5



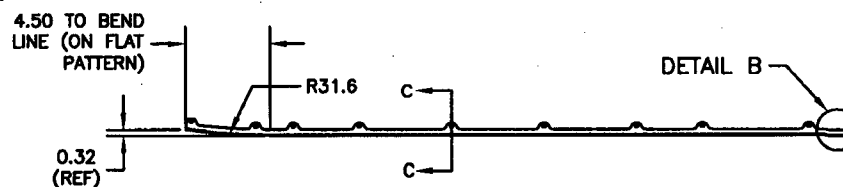
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
PH	PH	D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 1 OF 7
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC
		SCALE 1:10

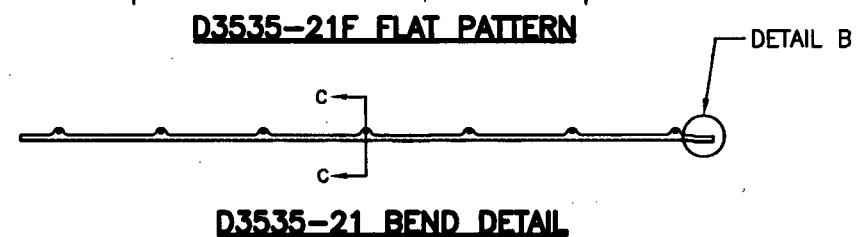
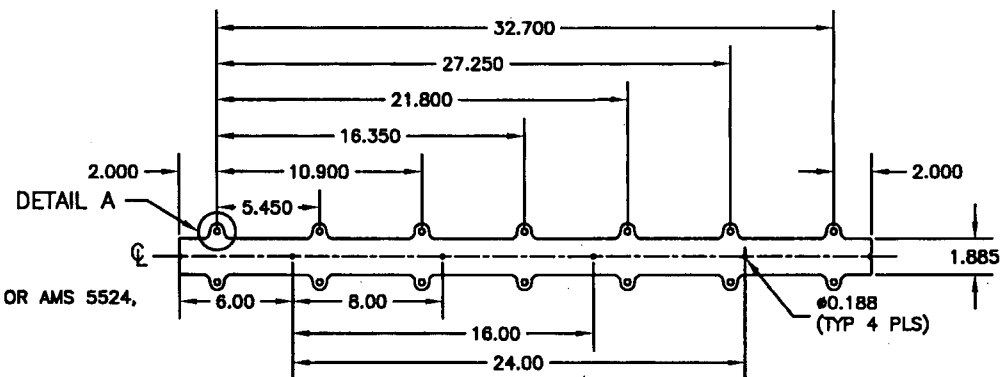
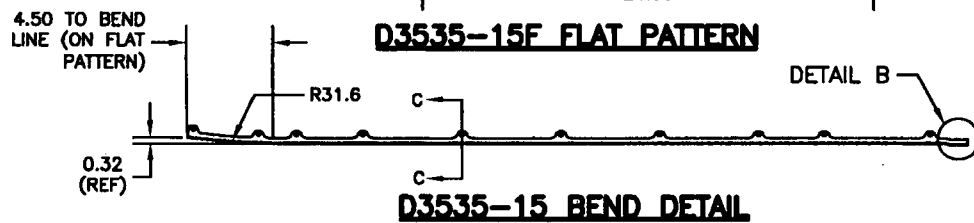
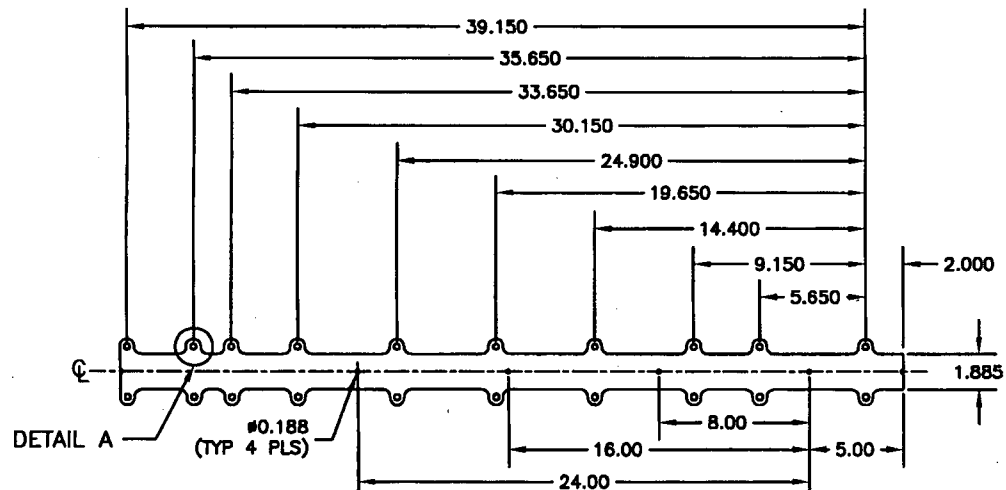
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		D3535
DATE	TITLE	SHEET 2 OF 7
07.04.17	WEARSHOE	SCALE 1:10



- NOTES**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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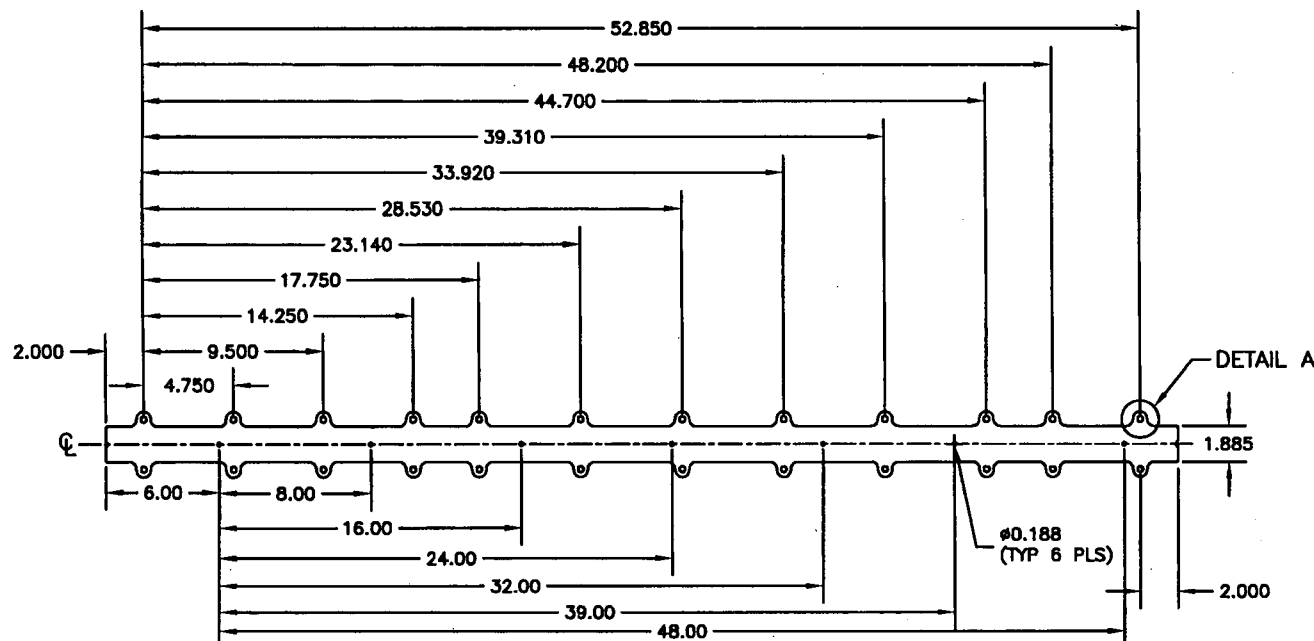
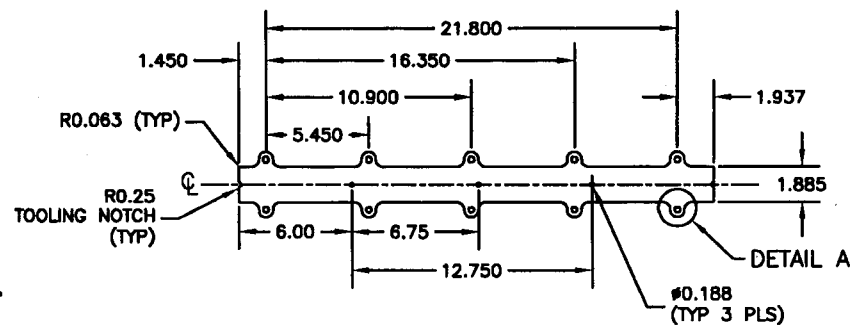
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w/o 53462

**D3535-23F FLAT PATTERN**C
C**D3535-23 BEND DETAIL****D3535-25F FLAT PATTERN**C
C**D3535-25 BEND DETAIL****NOTES**

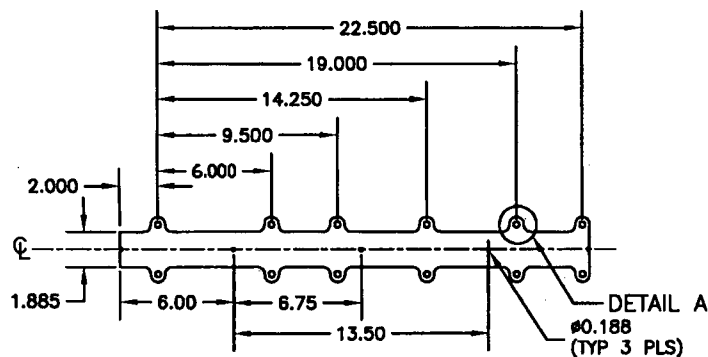
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CB	CH	PORT HADLOCK, WA	
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CH	CH	D3535	
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	

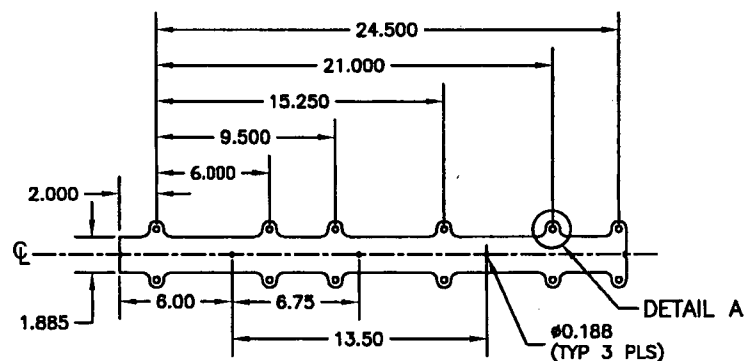
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**D3535-31F FLAT PATTERN****D3535-31 BEND DETAIL**

w/o 53462

**D3535-33F FLAT PATTERN****D3535-33 BEND DETAIL****NOTES**

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DATE	DATE	TITLE	SCALE
07.04.17	07.04.17	WEARSHOE	1:10

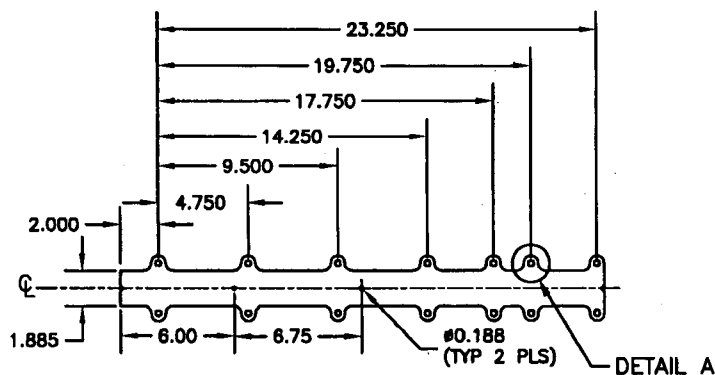
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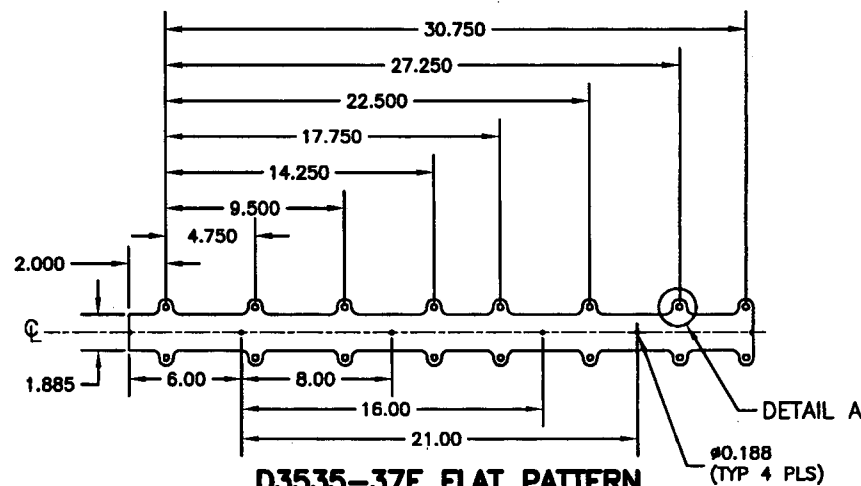
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DATE 07.04.17	TITLE WEARSHOE	SHEET 5 OF 7	SCALE 1:10



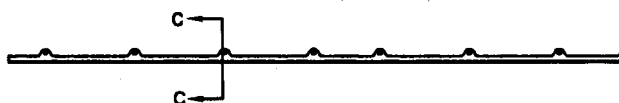
D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

NOTES

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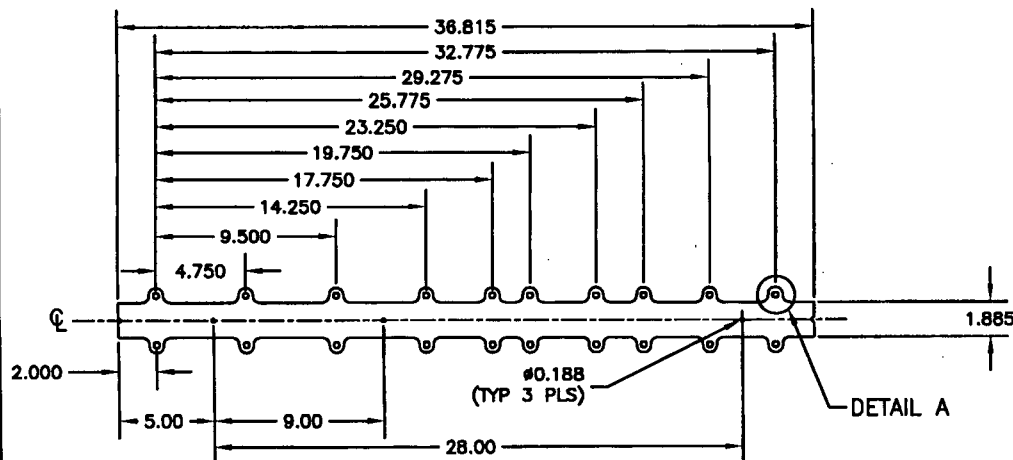
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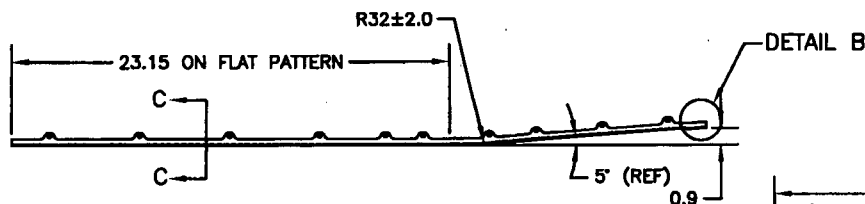
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W/O 53442

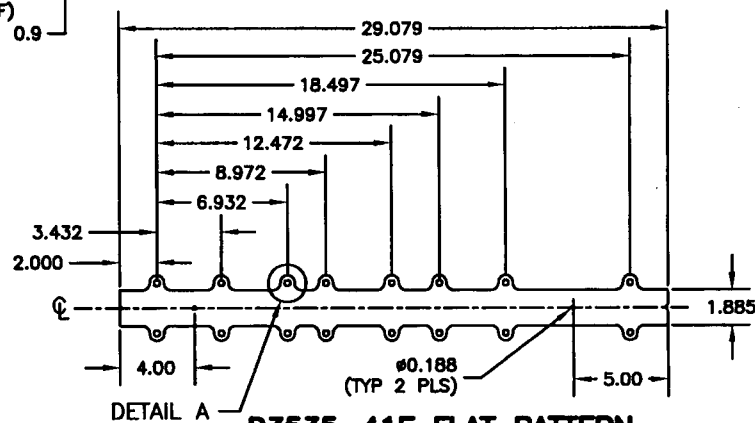
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DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 6 OF 7
		SCALE 1:10



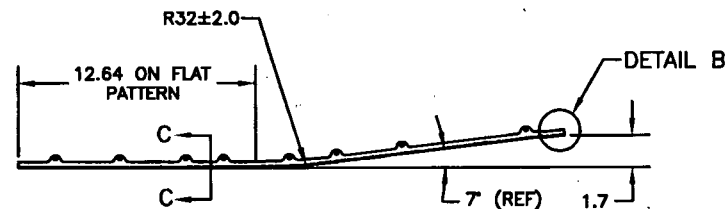
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

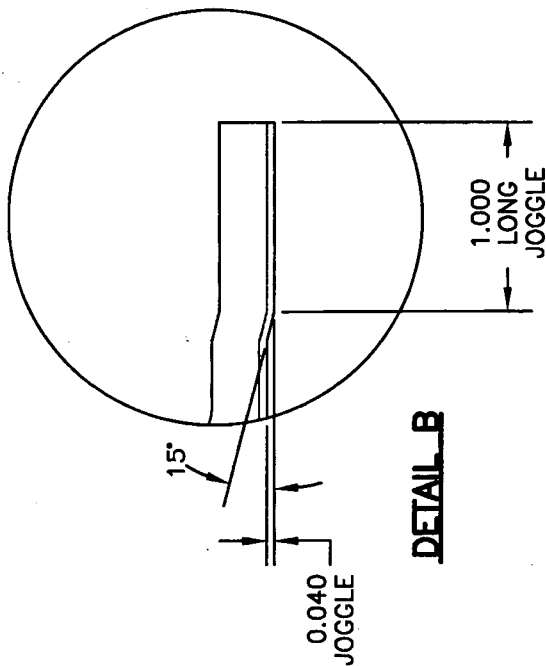
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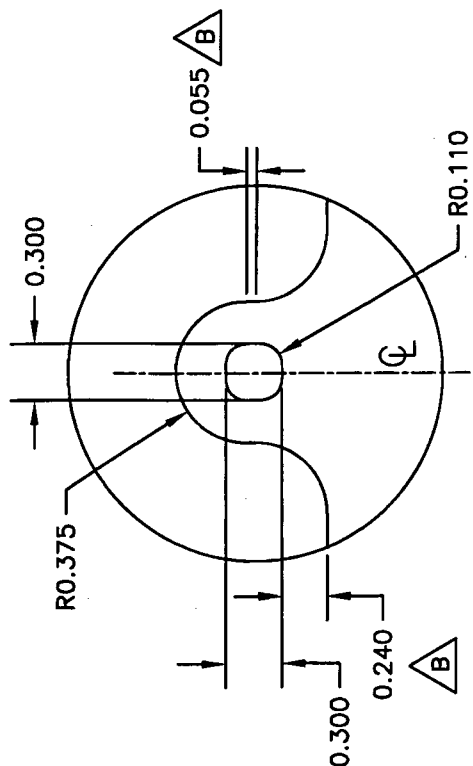


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DATE 07.04.17	TITLE WEARSHOE		SCALE 1:1

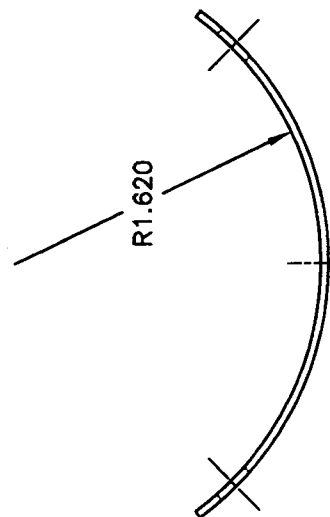
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DETAIL B



DETAIL A



SECTION C-C

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